
Product Information

EC530 En-V[™] Performance Clearcoat

Product Description

EC530 is a high gloss low VOC performance clearcoat designed specifically for use with ENVIROBASE[®] High Performance Waterborne Basecoat. This clearcoat reduces cycle times while maintaining the quality and appearance required by high production shops. From an environmental standpoint, the low VOC of EC530 clearcoat along with the high solids resin also decreases clearcoat material usage and therefore greatly reduces the overall VOC emissions.

Preparation of Substrate:



In all cases, wash all surfaces to be painted with soap and water, then use the appropriate ONECHOICE[®], GLOBAL REFINISH SYSTEM[®] or DELTRON[®] cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.



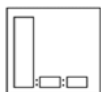
Wet sand with U.S. 500 - 600 / European P800 - 1200 grade paper or dry sanding with U.S. 400-500 / European P600 - 800 grade paper.



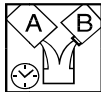
Wash off residue and dry thoroughly before re-cleaning with appropriate *OneChoice*, *Global Refinish System* or *Deltron* cleaner. The use of a SX1070 *OneChoice* Tack Rag is recommended.

APPLICATION GUIDE:

Mixing Ratio



EC530	3 Parts
ECH5075	1 Part
D87x/DT8xx	1 Part



Sprayable Pot life 2 hours @ 70°F (21°C)

Hardener

Reducer

ECH5075 Standard Hardener

D870 / DT860 : Up to 65 °F (18°C)
 D871 / DT870 : 65° - 75°F (18° - 25°C)
 D872 / DT885 : 75° - 95°F (25° - 35°C)
 D873 / DT895 : Over 95°F (35°C)

Optional Additives:



	EC530	ECH5075	D87x/DT8xx		DX814
DX814	3	1	1	+	DX814 ¼ up to ½ part to RTS qt.
DX73	3	1	1	+	DX73 1 oz. to RTS qt.
DT8110	3	1	1	+	DT8110 5% to RTS qt.

When EC530 is used on plastic parts, the addition of DX814 Universal flexibilizer is not required. For very flexible or leading edge parts, the addition of DX814 will improve overall flexibility.

Spray gun set-up:



Fluid Tip	1.3 - 1.5
Spray Viscosity	16 secs, DIN 4 @ 70°F (21°C)

Spray pressure:

HVLP	10 psi at the cap
Compliant	29 - 40 psi at the gun*
*Refer to the manufacturer's gun recommendations for inlet air pressures	

Number of coats:



Apply 2 medium wet coats

Film build:

Minimum Dry	2.0 mils
Maximum Dry	3.5 mils
Recommended film build per coat wet	2.0 - 2.5 mils
Recommended film build per coat dry	1.0 - 1.5 mils

Flash off at 70°F(21°C):



3 - 5 minutes between coats






Drying Times:



Dust-free	30 - 40 minutes
70°F (21°C)	
Air Dry to Re-assemble*	3 - 4 hour
70°F (21°C)	
Force Dry*	25 minutes @ 140°F (60°C)
Tape Time	3 - 4 hours
70°F (21°C)	
IR (Infrared)	N/A

*For in-Service delivery at low temperatures (below 60°F (16°C) or inclement weather conditions, allow EC530 a minimum of 4 hours air dry at shop temperature (above 60°F (16°C) or above) or bake for 25 minutes @ 140°F (60°C) metal temperature and cool for one hour prior to putting into service.

Overcoat / Recoat / Polishing

	Overcoat / Recoat time	6 - 8 hours at 70°F(21°C) air dry or after force dry for 25 minutes @ 140°F (60°C) metal temperature and cool down for one hour. EC530 must be sanded before recoating with primer, color or clear.
	Grade wet	U.S. 500 – 600 / European P800 - 1200
	Grade dry	U.S. 400 – 500 / European P600 - 800
	Overcoat with	<i>Envirobase</i> High Performance Basecoat, primer, sealer or clear
	Air dry: 4 - 5 hours Force cure: After cool down	Polishing is not normally required. If, however, polishing is required to remove minor dirt nibs, sand with P1500 or finer and follow normal polishing procedures.

Performance Guidelines

Allow basecoat to thoroughly dry before applying EC530 clearcoat. If allowed to dry longer than 24 hours, additional basecoat must be applied before clearcoating. The timing will depend on film thickness and temperature.

Fading Out EC530

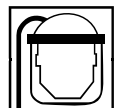
After spot repairing, Use *OneChoice* SX840 or SXA840 Uniform Finish Blender and apply starting from the outside of the repair moving towards the center of the repaired area to lose the clearcoat blend edge.

Technical Data

RTS Combinations:	EC530 : ECH5075 : D87x/DT8xx	EC530 : ECH5075 : D87x/DT8xx + DT8110	EC530 : ECH5075 : D87x/DT8xx + DX814
Volume Ratio:	3 : 1 : 1	3 : 1 : 1 + 5 %	3 : 1 : 1 + up to 1/2
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating (flexed)
VOC Regulatory (less water less exempt) (g/l)	213 - 308	264 - 343	272 - 348
VOC Regulatory (less water less exempt) (lbs/gal)	1.79 - 2.57	2.20 - 2.86	2.27 - 2.90
Solids wt. %	43.4 - 43.8	41.9 - 42.2	42.7 - 43.1
Solids vol. %	42.8 - 43.1	40.7 - 41.0	41.7 - 42.0
Sq. Ft. Coverage / U.S.gal. 1 mil. @ 100% transfer efficiency	687 - 691	653 - 658	669 - 674

Health and Safety

See Safety Data Sheet and Labels for additional safety information and handling instructions.



- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDS's of all the components, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

Emergency Medical or Spill Control Information (412) 434-4515; In Canada (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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